

WHAT IS CLAIMED IS

1. A transfer system comprising:

transfer lines (L) each of which forms a closed loop and has transfer-in stations (S_1 and S_3) and transfer-out stations (S_2 and S_4) for assembling parts (p_1 to p_5) to a work (D_L and D_R), while circulating the work (D_L and D_R) along the transfer line (L);

a work and part transfer passage (51) for transferring the work (D_L and D_R) and the parts (p_1 to p_5); and

sub-transfer-passages (52_1 and 52_2) branching out from the work and part transfer passage (51);

wherein longitudinal ends of each of the transfer lines (L) face a side of the work and part transfer passage (51);

wherein the transfer-in stations (S_1 and S_3) and the transfer-out stations (S_2 and S_4) are disposed at each of the longitudinal ends of each of the transfer lines (L); and

wherein the sub-transfer-passages (52_1 and 52_2) are disposed on longitudinally sides of the transfer lines (L).

2. A transfer system according to claim 1, wherein longitudinal ends of a pair of the transfer lines (L) face opposite sides of the work and part transfer passage (51).

3. A transfer system according to claim 2, wherein transfer directions of the pair of the transfer lines (L) disposed on the opposite sides of the work and part transfer passage (51) are reverse to each other; the transfer-in stations (S_1 and S_3) of one transfer line (L) oppose to the same of the other transfer line (L), with the work and part transfer passage (51) therebetween; and the transfer-out stations (S_2 and S_4) of one transfer line (L) oppose to the same of the other transfer line (L), with the work

and part transfer passage (51) therebetween.

4. A transfer system according to claim 1, wherein a pair of the transfer lines (L) are disposed along one side of the sub-transfer-passages (52₁ and 52₂), and another pair of the transfer lines (L) are disposed along the other side of the sub-transfer-passages (52₁ and 52₂).